

Date: Tuesday, 10/24/2006 11:02:42 AM
User: Kim Johnston

Process Sheet

| | | | | | | | |
|----------------------------------|---------------------------------------|-----------------|---|--------------------------------|----------------|------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : LID PRO ARM ASSEMBLY (SHORT) | | | |
| Job Number | : 29134 | | | | | | |
| Estimate Number | : 10258 | | | | | | |
| P.O. Number | : N/A | | Part Number | : D2332041 | | | |
| This Issue | : 10/24/2006 | S.O. No. | : N/A | Drawing Number | : D2332 REV C1 | | |
| Prsht Rev. | : NC | | Project Number | : N/A | | | |
| First Issue | : N/A | | Drawing Revision | : C1 | | | |
| Previous Run | : 28246 | | Material | : N/A | | | |
| Written By | : | | Due Date | : 11/10/2006 | | | |
| Checked & Approved By | : | | | Qty: | 20 | Um: | |
| Comment | : Est: B 02.08.10 | | Re-format; Incorporated D2332-13/-11/-7/-5KJ/ RF | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|--|--|
| 1.0 | M304TR1000WO49 | 304 RD Tube 1.0" x .049W  |
| | |  |
| | Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless) <u>m19448</u> | Batch <u>MF.</u> 06-11-13 |
| 2.0 | M304R250 | 1/4" 304 SS Roundbar  |
| | |  |
| | Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s) Material: Ø0.250" 304SS Rod Batch <u>m17931</u> | <u>MF.</u> 06-11-13 |
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1  |
| | |  |
| | Comment: SMALL & MEDIUM FAB RESOURCE 1 | |
| | 1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar | <u>MF.</u> 06-11-13 (20) |
| | 2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin | <u>MF.</u> 06-11-13 (20) |
| | 3-Deburr | <u>MF.</u> 06-11-14 |
| 4.0 | M304TR0500WO035 | 304 RD Tube .500 x .035W  |
| | |  |
| | Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s) 304 RD Tube .500 x .035W | <u>MF.</u> 06-11-09 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:02:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 29134

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

~~M101593x9~~

~~M102450x36~~

FF 06-11-09

40

✓ Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly) MF. 06-11-15 (20)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298.-(Weld 1 per assembly)

A/R SS Rod Batch: M101972

~~Exp 06-11-20~~

(20)

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/06/11/20 (20)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/06/11/20 (20)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

MF. 06-12-18

20

2-Assemble as per Dwg D2332

MF. 06-12-19

10.0 AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M100857

MF. 06-12-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/20
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:02:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 29134

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 3 | AN960JD416L | Washer | m101237 |

12.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | MS21042L4 | Nut (or -4) | m19185 |

MF. 06-12-19

20

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/19 (20)

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location 5169

06/12/19 (20)

(20)

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/20

Job Completion



06/12/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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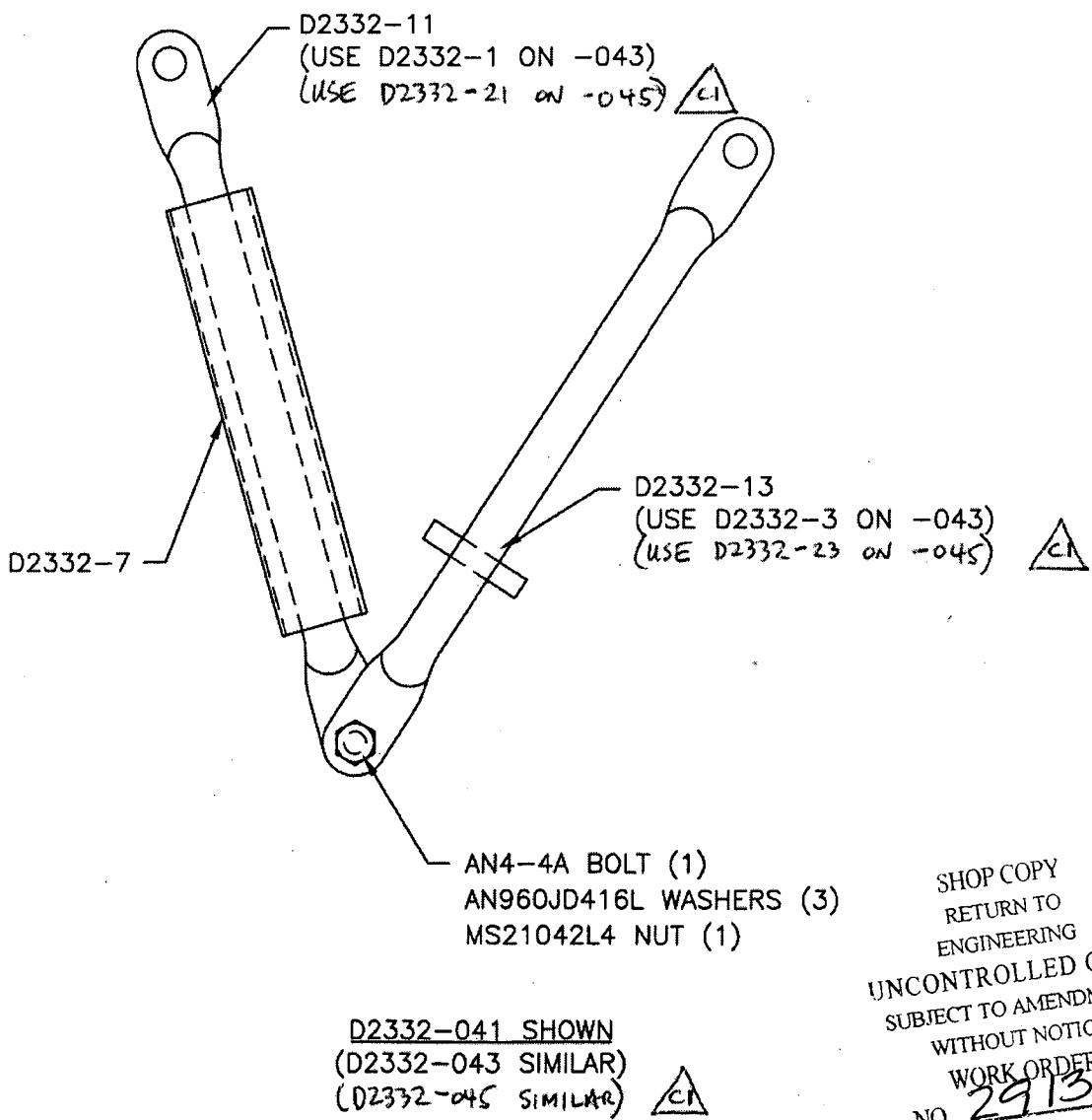
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. C |
| | | D2332 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 03.07.03 | | LOD PROP ASSEMBLY | NTS |
| A | 94.12.16 | NEW ISSUE | |
| B | 97.09.30 | CHANGE 416 WASHERS TO 416L | |
| C | 03.07.03 | MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.) | |
| C1 | 03.08.06 | ADD -045 PROP (7.25" LONG) | |

RELEASED
 03.07.04


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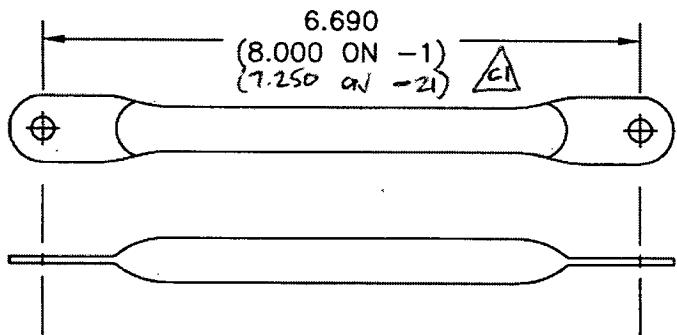
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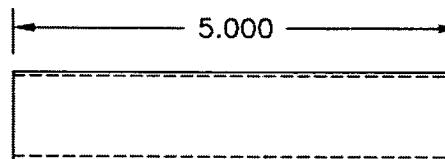
DESIGN **H**
DRAWN BY **L**
DATE **03.07.03**
TITLE **LID PROP ASSEMBLY**
SCALE **1:2**

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. C
SHEET 2 OF 2

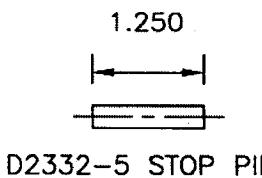
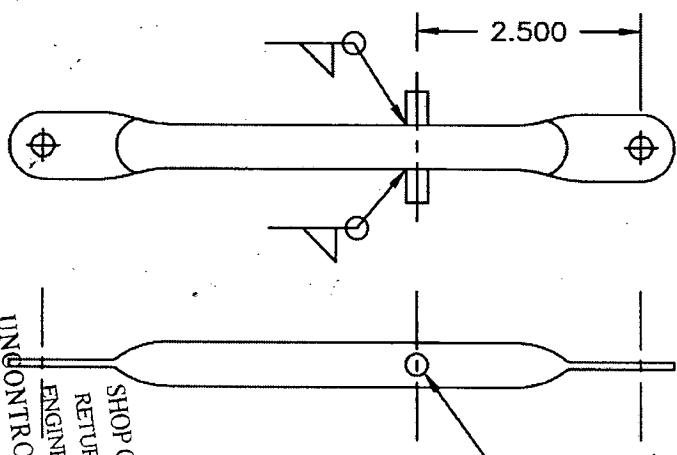
| CHECKED | APPROVED | DRAWING NO. |
|-----------|----------|--|
| C | H | D2332 |
| C1 | H | 03.08.06 ADD -045 Prop (7.25" long) |



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

D2332-13

M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

WORK ORDER
NO. 29134

SUBJECT TO AMENDMENT
WITHOUT NOTICE

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03.07.04